121238

Page 1

June-18-14 1:58:14 PM

| J IIII 20 27 210012723 | 5 10 100 | | | | | | | | | | 115 6 |
|---|--------------------------|-------------------------------|----------------------|----|----------|-------|--------------|---------------|---------------|------------------|-------------------|
| Item ID: D3463 Revision ID: | | | Accept | *N | 900 | 040 | 10 |) * | Setup Sta | 171 | S1* |
| Item Name: Drag A Start Date: 6/18/14 Required Date: 6/18/14 Reference: | 4 Start Qty: 20.00 | *20* | (10) | | ıst Item | | | | 310 | * *N | S2* |
| Approvals: Proce | ess Plan: MUS | Date: 14-06-18 | Tooling: | | D | ate: | | I | Run Sta | ~1/1 | R1* |
| QC: | | Date: | SPC (Y/N): | 8- | D | ate: | | | Sto | *N | R2* |
| Sequence ID/ Work Center ID | Operation Description | | Set Up/ Run Hours | Т | Cool ID | Tool# | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr | Revision Nbr | | 12. 3 | | | | | | 11 100 | | |
| D3463 | Rev B | | | * | | 3.7 | | | | | |
| 100 | | W _ 1 7 2 | 0.00 | | | | | | | | |
| *100* | Small Fab | | | | | | | 20x | DAS | OCT | 2 0 2014 |
| Small Fab | Memo | | 0.00 | | | | | | 28 9-89 | DAS | |
| Small Fab | 1-Cut to 13 | 3.875" | | | | | | | 000 | 30 | |
| 1025 | 2-Deburr 3-Bend end | d as per dwg D3463 | | | | | | | | 9-89 | DA6 38 9-89 |
| 110 | OC5- Inspect part comp | pleteness to step on W/O | 0.00 | | | | | | DAS | A CONTRACT | 1 |
| *110* | | | | | | | | 20 | 51 | 141 | 10/20 |
| QC | Memo | | 0.00 | | | | | 40 | 9-89 | | |
| Quality Control | -1 | | | | | | | | | 1 | |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| 120 | | | 0.00 | | | | | | | | DAS 37 |
| | CONVENTIONAL MII | LLING MACHINE | 0.00 | | | | | 0 0 | ~ | | 0.00 |
| *120* Mill Conv | | | 0.00 | | | | | 20 | Ø | | 7.C.L. |
| Conventional Milling Machin | Memo | er dwg D3463 | 0.00 | | | | | | | | 14/10/22 |
| Conventional winning Macinii | | e & ream to 0.4385" as per dv | /g D3463 | | | | | | | | |

| DQA: | 9 | (ot | Date: | 14/1 | 2/08 | | | | | IDDATE | | | PART | |
|---|----------------------------------|-----------|--------------------|---------|----------------------|---|------------|------------------------|--|-----------|-------------------|-------------------------------|--------------------|--|
| QA Closed: | 3 | MS | , Date: | 141 | 12/ | WORK ORDER NON- | -CC | ONFO | RMANCE / U | | Work Order u | pdate only | AEROSPACE | |
| Work Orde | | | | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
| WOIK OIGE | -1. | 1 - 1 | | | _ | Rework | | | Skid-tube | Crosstube | | Water Jet | Engineering | |
| Part No. <u>D</u> 3463-7 Scrap | | | | | 1 | Machining | Small Fab | Pro | d. Eng. Coor. | Quality | | | | |
| Use-as-is ✓ | | | | | Thern | noforming | Finishing | Rec/Sto | re/Packaging | Other | | | | |
| NCR No. 14 - 4340 Suspected Unapprove | | | | | Suspected Unapproved | | | Large Fab | Composite | | Supplier | | | |
| Root | П | | | | Desc | ription of work order update | | nitial | Ad | ction | Sign & | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Desc | cription | Date | Verification | QC Inspector | |
| Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training | + | 14/10/24 | 120 | | of. | le 15 up to 0.013 If center. Longth 13.50 is 13.417 to 13.558 Openation Eviden. | | DAS 12 9-89 | Acceptable. Wolding jig will CHELLER correct any alignment problems. | | DAS 12 9-89 | DAS 20 9-89 14-10-24 | DAS 16 9-89 | |
| Transport Unapproved | | | | 25/2 | | | | | | | | | | |
| | a. | | | 100 | , | | FAI | ULT CAT | regory | | | | | |
| Landi | ng G | ear | | 10% | | General | | | | | -6 | _ | _ | |
| | 100 | Bending | | | | Bend | | | rogram | | ✓ Outside Din | | Pressure/Forced | |
| | | Centre No | t Concen | ntric | | BOM/Route | | Grain | | | Over/Under | - | Set-up | |
| | | Cracks | | | | Broken/Damage/Defect | | Hardwa | | | Part Incorre | _ | Temperature/Cure | |
| AO | | Crimp/Kin | k/Ripple, | /Wave | | Burrs | _ | | ion Incomplete/U | | Part Lost/M | | Weld | |
| 10 | | Cuffs | | | | Contamination | | the second second | ions Incomplete | | Part Moved | - | Wrong Stock Pulled | |
| 4. | | Crushing | | | | Countersink | | MIN . | ned/off center | | Positioned | | 704 | |
| 1 | | Heat Trea | | | 3 | Cut Too Short | 200 | Mislabe | | l | Power Loss, | Surge | Other | |
| | Inspection Strip in Tube Drawing | | | Misread | | | | | | | | | | |
| | Marks/Chatter Drill Holes | | | Off-set | | | | | - 4 | | | | | |
| Turning Sequence Finish | | | Out of Calibration | | | | | | | | | | | |
| Wave/Twist in Tube Fit/Function | | | | | Out of | Sequence | 二十年 汽车的工业层 | AND THE REAL PROPERTY. | The state of the s | | | | | |

Work Order ID 121238

150

Small Fab

Small Fab

121238

Page 2

28 9-89

10x

June-18-14 1:58:14 PM Accept Item ID: D3463-7 *N900040100* Setup Start **Revision ID:** Stop Item Name: Drag Arm Start Oty: 20.00 *20* Start Date: 6/18/14 Cust Item ID: Required Date: 6/18/14 Reg'd Oty: 20.00 *20* Customer: Reference: Start Run Approvals: Process Plan: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Plan Sequence ID/ Operation Set Up/ Tool ID Tool# Reject Accept Reject Insp. Work Center ID Description Qty Qty Stamp Run Hours Code Number DAS 130 QC2- Inspect parts off machine FAI/FAIB 0.00 37 *130* 20 9-89 OC 0.00 Memo Quality Control 140 QC8- Inspect parts - second check 0.00 DAS 20 8 *140* QC 0.00 Memo Quality Control 150 0.00 DAS OCT 2 9 2014 Small Fab

0.00

Memo

Grind .450" rad

| DQA: | | | Date: | Date: | | | | | DAR | | | | | |
|---------------|---------------------------------|------------|----------|----------------------------------|-------------|----------------------|--|---------|----------------------------|---------------|---------------------------|--------------------|---------------------------------------|-------|
| QA Closed: | | | Date: | | | WORK ORDER NON- | ·CC | ONFO | RMANCE / UPDATE | W | ork Order up | date only | AEROSPA | A C E |
| QA Closed. | | | Date. | | | | | | AGAINST DEPARTMENT/PROCESS | | | | | |
| Work Ord | er: | | | | | DISPOSITION | | | AGAINST | /PROCESS | | _ | | |
| | | | | | | Rework | | | Skid-tube Crosstube | | | Water Jet | Engineering | |
| Part I | No. | | | | | Scrap | | | Machining Small Fab | $\overline{}$ | - | d. Eng. Coor. | Quality | - 1 |
| | | | | | | Use-as-is | | Thern | noforming Finishing | | Rec/Stor | re/Packaging | Other | - 1 |
| NCR I | NCR No Suspected Unapproved | | | | | | Large Fab Composite | | J | Supplier | | _ | | |
| Root | | | | Description of work order update | | | | nitial | Action | | Sign & | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspecto | or |
| Design | | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | 1 | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | |
| Training A | 1 | | | | | | | | | | | | | |
| Transport 05 | | | | | | | | | | | | | | |
| Unapproved | | | | - | | | FΔI | ULT CA | TEGORY | | | | | |
| Landi | ng G | lear | | | | General | | 011 011 | | | | | | |
| Sarrai | | Bending | | | | Bend | | Folio/F | Program | | Outside Dim | ensions | Pressure/Forced | |
| | | Centre No | t Concer | ntric | | BOM/Route | | Grain | | | Over/Under | tolerance | Set-up | |
| ,vi | 90 | Cracks | des. | | | Broken/Damage/Defect | | Hardwa | are | | Part Incorre | ci | Temperature/Cu | re |
| | | Crimp/Kin | k/Ripple | /Wave | 251 | Burrs | Total | Inspect | ion Incomplete/Unqualified | | Part Lost/Mi | issing | Weld | |
| | - | Cuffs | | | | Contamination | | Instruc | tions Incomplete/Unclear | 146 | Part Moved | | Wrong Stock Pul | led |
| | | Crushing | | | | Countersink | | Misalig | gned/off center | | Positioned V | Vrong | | |
| | | Heat Trea | t | | of the same | Cut Too Short | | Mislabe | eled | | Power Loss/ | Surge | Other | |
| | | Inspection | Strip in | Tube | 1 | Drawing | 1 | Misrea | d | | at the state of the state | ALT 4 | 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 | 173 |
| | 1.150 | Marks/Ch | atter | A state of | | Drill Holes | - | Off-set | | | 1 4 34 25 3 4 | * The state of the | | 1 |
| | | Turning Se | equence | | , 基层 | Finish | 32 | Out of | Calibration | | A STATE | | | - |
| 25 303 | Wave/Twist in Tube Fit/Function | | 9495 | Out of | Sequence | 2 5 | Land - The Party of the Party o | | | | | | | |

Work Order ID 121238

121238

Page 3

June-18-14 1:58:14 PM D3463-7 Accept Item ID: Setup Start *N900040100* Revision ID: Stop **Item Name:** Drag Arm *20* Start Qty: 20.00 **Start Date:** 6/18/14 Cust Item ID: Required Date: 6/18/14 Reg'd Otv: 20.00 *20* **Customer:** Reference: Run Start Tooling: Process Plan: Approvals: Date: Date: Stop SPC (Y/N): OC: Date: Date: Reject Reject Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Insp. Number Stamp **Work Center ID** Code Qty Qty Description **Run Hours** 160 QC5- Inspect part completeness to step on W/O 0.00 DAS HO *160* 16 14/10/29 OC 0.00 9-89 Memo Quality Control DAS Identify as per dwg & Stock Location: WAOOZ 170 0.00 46 *170* 9-89 Packaging 0.00 Memo OCT 3 0 2014 Packaging 14/11/3 A 180 QC21- Final Inspection - Work Order Release 0.00 *120* QC 0.00 Memo Quality Control

| DQA: | | | Date: | | | | | | AG | | | | | | | |
|---------------------|--|------------|----------|---------------------------------------|----------------------|------------------------|-----|---------|----------------------------|---------------|-----------------------------|--|----------------------------|--|--|--|
| | | | | | | WORK ORDER NON- | -CC | ONFO | RMANCE / UPDATE | | | _ | AEROSPACE | | | |
| QA Closed: | | | Date: | | | | | | Work Order update only | | | | | | | |
| | | | | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | |
| Work Ord | er: | | | | _ | Dawe who | | | Skid-tube Crosstube | | 1 | Water Jet | Engineering | | | |
| Dort | la. | | | | | Rework Scrap | | | Machining Small Fab | _ | Pro | d. Eng. Coor. | Quality | | | |
| Part I | VO | | | | _ | Use-as-is | | | noforming Finishing | | | e/Packaging | Other | | | |
| NCR | Vo. | | | | | Suspected Unapproved | | 1110111 | Large Fab Composite | $\overline{}$ | | Supplier | | | | |
| ,,,,,, | | | | | Suspected onapproved | | | | | | | | | | | |
| Root | | | - | Description of work order update | | | - | nitial | Action | | Sign & | | | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector | | | |
| Design | | | | | | | | | | | | | | | | |
| Doc/Data | | * | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | | | | |
| Process Supplier | Н | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | | | | |
| Unapproved | П | | | | | | | | | | | | | | | |
| \$101 de | 30 | | | | | | FAI | ULT CAT | TEGORY | | | | | | | |
| Landi | ng G | Gear | | | | General | | | | _ | , | _ | 7 | | | |
| | | Bending | | | | Bend | | | rogram | | Outside Dim | A CONTRACTOR OF THE PARTY OF TH | Pressure/Forced | | | |
| | | Centre No | t Concer | ntric | | BOM/Route | | Grain | | | Over/Under | _ | Set-up | | | |
| | - | Cracks | | | | Broken/Damage/Defect | | Hardwa | | - | Part Incorred | _ | Temperature/Cure | | | |
| | | Crimp/Kin | k/Ripple | /Wave | | Burrs | | | ion Incomplete/Unqualified | - | Part Lost/Mi | ssing | Weld | | | |
| | | Cuffs | | | _ | Contamination | _ | 4 | cions Incomplete/Unclear | - | Part Moved | /rong | Wrong Stock Pulled | | | |
| | - | Crushing | , i | | | Countersink | - | Mislabe | ned/off center | - | Positioned W Power Loss/ | | Other | | | |
| | - | Heat Treat | | Tubo | 200 | Cut Too Short | | Misrea | | | Jrower Loss/ | ouige | Ostrici | | | |
| | | Inspection | | Tube | Page Control | Drawing Drill Holes | | Off-set | | | - | 20 Dec 20 | Aller of Search and Search | | | |
| | | | - A | · · · · · · · · · · · · · · · · · · · | Out of Calibration | | | | | | | | | | | |
| | Turning Sequence Finish Wave/Twist in Tube Fit/Function | | | Out of Sequence | | | | | | | | | | | | |

Picklist Print

June-18-14 1:58:18 PM

Work Order ID: 121238

D3463-7

121238 *D3463-7*

Parent Item Name: Drag Arm

Start Date: 6/18/14

Required Date: 6/18/14

Page 1

Start Qty: 20.00

Required Qty: 20.00

9985

Comments:

Parent Item:

IPP REV> A 05.11.18

new issue

IPP Rev:B Added Step 7 08-11-04 JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------------|
| M304TR0.750W.120 | | Purchased | No | | | 100 | f | 41.7500 | 1.15625 | 25 | | | |
| *M304TR0 | 750\/ | 120* | | | | | | | ** | | DA | | OCT 2 0 2014 |

304 ss round tube .750 x .120w

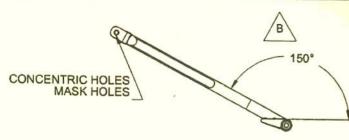
Location Loc Oty Loc Code MAT017 41.75 125656 41.75

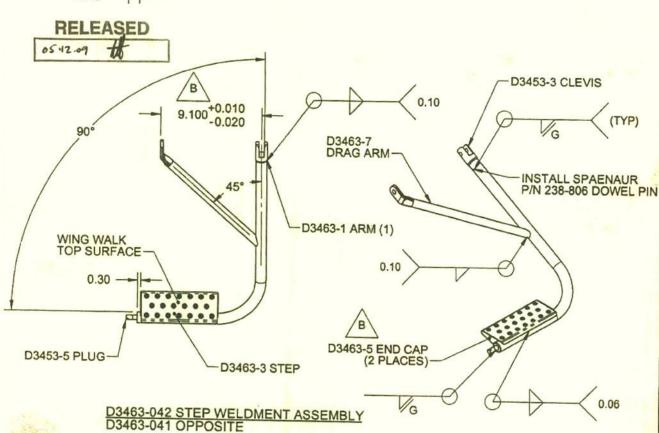
| DQA: | | | Date: | 27 | | | | | | | | | DART |
|-----------------------|---------------------------------|----------------------------------|----------|--------------------|-----|----------------------|--------------------|-------------------|----------------------------|-----------|---------------|---------------|--------------------|
| | | | | | | WORK ORDER NON- | -CC | ONFO | | | * * | <u></u> | AEROSPACE |
| QA Closed: | | | Date: | | | | | | | Wo | ork Order up | date only | i ist |
| Work Orde | er: | | | | | DISPOSITION | | | AGAINST | DEI | PARTMENT | /PROCESS | |
| | _ | | | | _ | Rework | | | Skid-tube Crosstube | Water Jet | Engineering | | |
| Part N | lo. | | | | | Scrap | | | Machining Small Fab | | Pro | d. Eng. Coor. | Quality |
| | | | | | _ | Use-as-is | - / | Thern | noforming Finishing | | Rec/Stor | re/Packaging | Other |
| NCR N | lo | | | | | Suspected Unapproved | | | Large Fab Composite | Ш | | Supplier | |
| Root | Т | Description of work order update | | | ı | nitial | Action | _ | Sign & | | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | - | Date | Verification | QC Inspector |
| Design | 30 | 2000 | | | | 30 | | | | | | | |
| Doc/Data | | dr. | | | | | | | | | | | |
| Equip/Tooling | | * | - A | | 200 | | | | | | | | |
| Handling/Pre | | | 1 | × × 0 | | | | | | | | ** | |
| Material | 4 | 1 | | | | 140 | | | | | | ' | |
| Operator | - | 100 | | | | | | | ¥ | | | 8 | |
| Offset/Setup | | M | | | | | | | | | | | |
| Process | - | 4 | | | 1 | | | | | | | | |
| Supplier | - 5 | | | | | | | | | | | | |
| Training Transport | \dashv | | | | | | | | | | | | |
| Unapproved | \dashv | - | | | | | | | | | | | |
| - Inapproved | | | 364 | | | | FAL | ULT CAT | TEGORY | | | | |
| Landin | ng Ge | ar | THEFT | | | General | | | | | | 13 | OK . |
| | | ending # | | | - | Bend | | Folio/F | Program | | Outside Dim | ensions | Pressure/Forced |
| 120 | C | entre No | t Concer | itric | | BOM/Route | | Grain | | | Over/Under | tolerance | Set-up |
| | | racks | A | | | Broken/Damage/Defect | | Hardwa | are | | Part Incorred | i S | Temperature/Cure |
| - 3/8 | C | rimp/Kin | k/Ripple | /Wave | | Burrs | pe 76 | Inspect | ion Incomplete/Unqualified | | Part Lost/Mi | ssing | Weld |
| 1. | C | uffs | 111 | | | Contamination | THE PARTY NAMED IN | Instruct | tions Incomplete/Unclear | | Part Moved | | Wrong Stock Pulled |
| | C | rushing | | 5 | 2 | Countersink | The second | The second second | gned/off center | | Positioned V | | |
| | 100 | leat Treat | | | - | Cut Too Short | | Mislabe | | 0 | Power Loss/ | Surge | Other |
| 22 F 12 2.4 | | nspection | 10.00 | Tube | | Drawing | -1 | Misread | | 4 29 | * | C. C. Marine | |
| 4.5 | | //arks/Cha | | - V | | Drill Holes | 1 | Off-set | | C - 5 | - | | |
| 47.65 | Turning Sequence Finish | | | Out of Calibration | | | | | 75,00° Ves. 1 | | | | |
| | Wave/Twist in Tube Fit/Function | | | Fit/Function | 1 | Out of | Sequence | Ala . | | * ** | A Comment | | |





INSTALL P/N 238-806 DOWEL PIN (TYP) MASK AREA 1.045 -





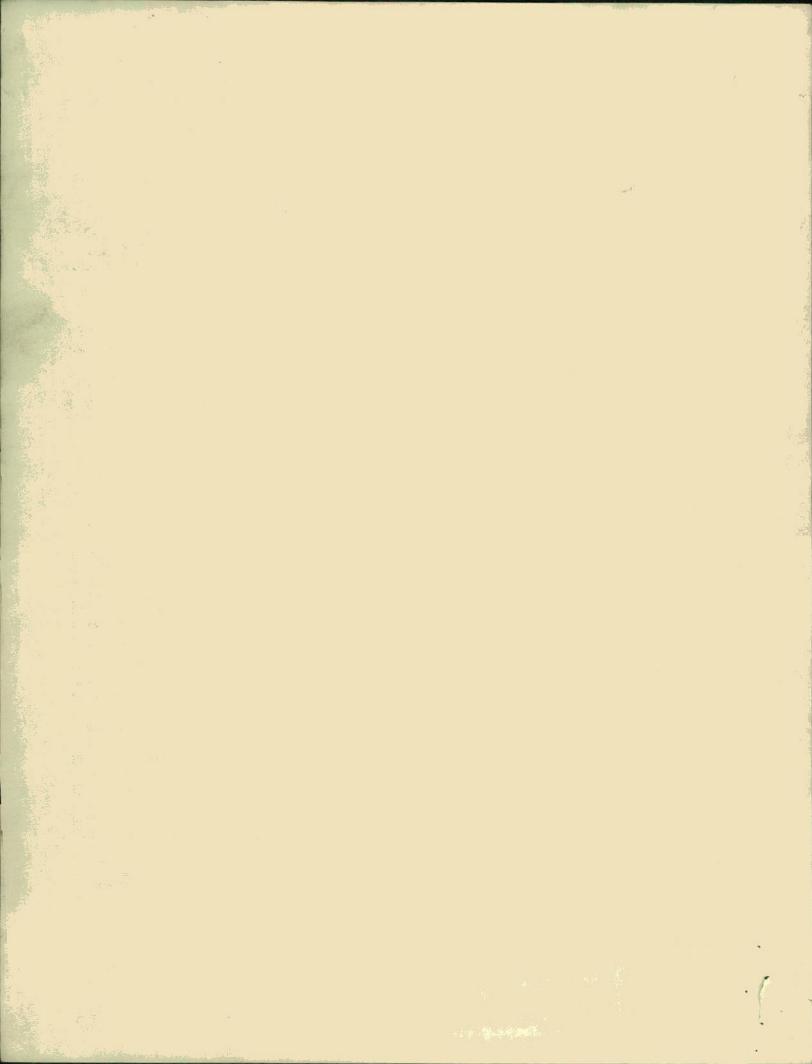
NOTES:

- 1) WELD PER DART QSI 004
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) REFERENCE IN INCHES

- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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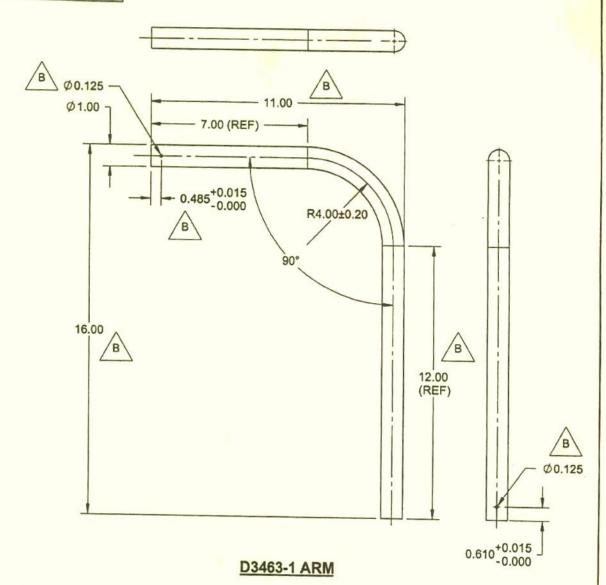
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| DESIGN RF | DRAWN BY RF | DART AEROSPAC HAWKESBURY, ONTARIO, | |
|--------------|----------------|---------------------------------------|------------------------|
| CHECKED | APPROVED | DRAWING NO. | REV. B SHEET 2 OF 4 |
| DATE 05. | 12.05 | STEP WELDMENT | SCALE 1:4 |

RELEASED 05.12.09



NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120) 1) MATERIAL: AISI 310/304 35 SEAMLESS TUBING (REF. DART SPEC. IV 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

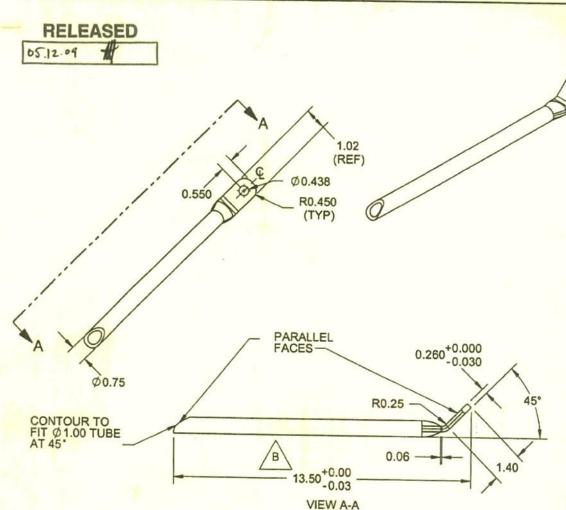
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| DESIGN RF | DRAWN BY RF | DART AEROSPAC HAWKESBURY, ONTARIO, | |
|--------------|----------------|---------------------------------------|------------------------|
| CHECKED | APPROVED | DRAWING NO. D3463 | REV. B SHEET 3 OF 4 |
| 05.1 | 2.05 | STEP WELDMENT | SCALE 1:4 |

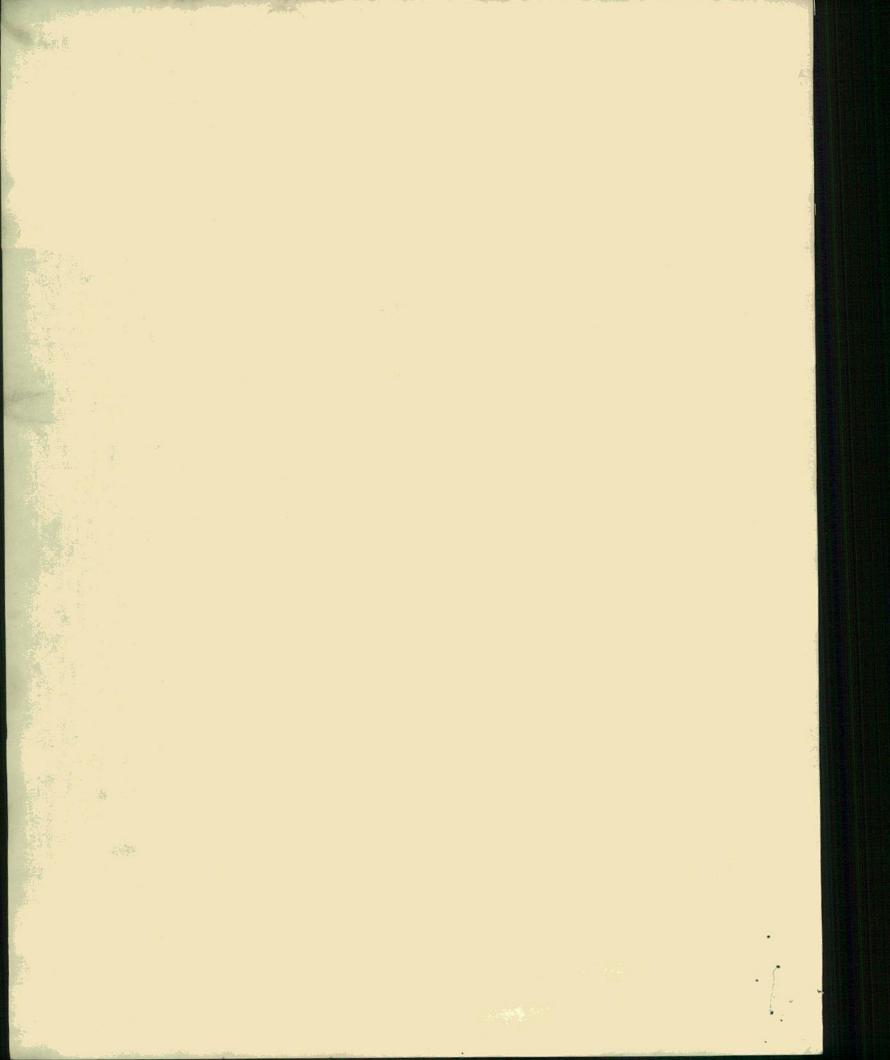


D3463-7 DRAG ARM

NOTES:

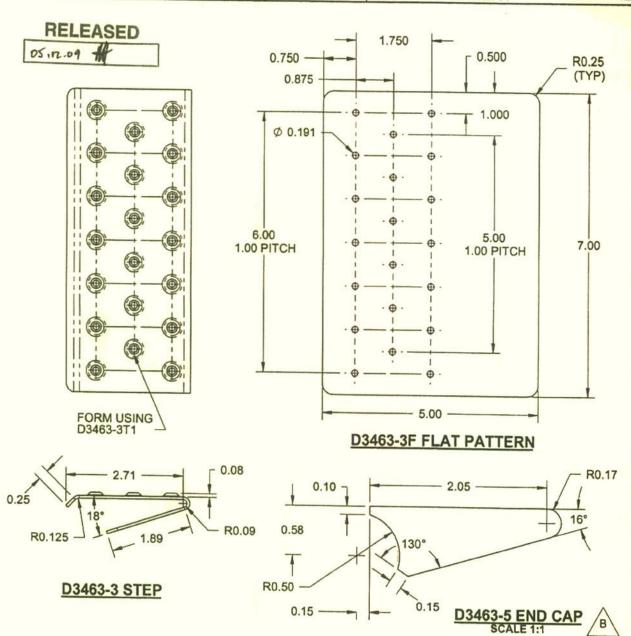
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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| DESIGN RF | DRAWN BY RF | DART AEROSPACE HAWKESBURY, ONTARIO | |
|--------------|----------------|------------------------------------|------------------------|
| CHECKED | APPROVED | D3463 | REV. B SHEET 4 OF 4 |
| 05. | 12.05 | STEP WELDMENT | SCALE 1:2 |



NOTES:

- MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA) 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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| DART AEROSPACE LTD | Work Order: | 12 238 |
|--------------------------------|--------------|-------------|
| Description: Drag Arm | Part Number: | 03463-7 |
| aspection Dwg: 0 3 4 63 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|--------------------|---------------------|--------|--------|-------------------------|----------|
| 13.50 | + 0.000 - 0.030 | 13.500 | 0 | | It.6. | 31006 |
| 0.260 | + 0.000 | 0.258 | V | | Caliper | JCL-08 |
| 0.550 | t/- 0.010 | 0-550 | V | | 11 | |
| Ø 0.478 | t 0. 006 | 0.438 | / | | 11 | |
| Ø 0.15 | 4-0-030 | 0.748 | 1 | | 11 | |
| 450 | t- 0.5° | 450 | V | | Angle reportor | |
| 1.40 | t- 0.030 | 1.400 | V | | Caliper | JCL-08 |
| 9.100 | +0.010 | 9,100 | | | | |
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| Date: | 14-10-24 |

| Preliminary Approval: | |
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| Rev | | Change | KI | |
| E | 10.04.14 | Added preliminary approval | No | |

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|--------------------------|---|-----------|---------------------------------------|------|------------------------------|----------|--|--|---|---|--|--|--|
| QA Closed: | . 4 | Date: | | | WORK ORDER NON | -co | NFO | A STATE OF THE PARTY OF THE PAR | ork Order ur | odate only | AEROSPACE | | |
| | | | | | | | | Work Order update only AGAINST DEPARTMENT/PROCESS | | | | | |
| Work Order: | Work Order: DISPOSITION | | | | | | | AGAINST DE | PARTIVIENT | PROCESS | <u> </u> | | |
| Rework | | | | | | | | Skid-tube Crosstube | | Water Jet | Engineering | | |
| Part No. | Part No Scrap | | | | | | | Machining Small Fab | | d. Eng. Coor. | Quality | | |
| NCD No. | | | | | Use-as-is | | | noforming Finishing | Rec/Sto | re/Packaging | Other | | |
| NCR No. | • | | | _ | Suspected Unapproved | | | Large Fab Composite | Marchine Services | Supplier | J- LJ | | |
| Root | | | | Desc | ription of work order update | In | nitial | Action | Sign & | 2 | The state of the s | | |
| Cause ' | Date | Step | Qty | | or non-conformance | Chi | ef Eng | Description | Date | Verification | QC Inspector | | |
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| Handling/Pre Material | 76 | | | | | | | | | | 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - | | |
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| | 1,0 | | | | | FAU | LT CAT | TEGORY | | | · · · · · · · · · · · · · · · · · · · | | |
| Landing | THE RESERVE TO SERVE THE PARTY OF THE PARTY | | | | General | | F - 1' - /D | | 1 | . 7 | 1- /- | | |
| | Bending Centre No | at Cancar | atric | | Bend BOM/Route | | Folio/P Grain | rogram | Outside Dim | _ | Pressure/Forced | | |
| 100 | Cracks | or concer | ILTIC - | | Broken/Damage/Defect | | Hardwa | ro | Over/Under tolerance Set-up Part Incorrect Temperature/Cure | | | | |
| | Crimp/Kink/Ripple/Wave Burrs | | | | | | | on Incomplete/Unqualified | Part Lost/Mi | _ | Weld | | |
| | Cuffs Contamination | | | | | | Instructions Incomplete/Unclear Part Moved | | | | Wrong Stock Pulled | | |
| | Crushing | | | | Countersink | - | | ned/off center | Positioned Wrong | | | | |
| | Heat Trea | it | e e e e e e e e e e e e e e e e e e e | | Cut Too Short | | Mislabe | led | Power Loss/Surge Other | | | | |
| | Inspection Strip in Tube Drawing | | | | | | Misread | | | | | | |
| 5 4 5 5 | Marks/Chatter Drill Holes | | | | | \vdash | Off-set | | | | 1 | | |
| | Turning Sequence Finish | | | | | \vdash | | Calibration | - | | | | |
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| H:/FORWIS/Quality | / Assurance\a | pproved Q | A/NCRWC | RevH | and of | | 4.24 | | | Alexander Title | ac. Carteria | | |